



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-667-107BL
Job Sheet 168325-E



Part No: D206-667-107BL

Job Qty: 1 ea

Part Name: Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/20/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Air Evac Lifetech (CAEVA02)

Air Medical Group Holdings, Concur Invoice Capture C/O (*AEL*), 10700 Prairie Lakes Drive Eden Prairie, MN, 55344 USA ph:(636) 695-5385

Note: LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417M-13

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	1 Ea		11/17/17	0.00	0.00	Start Up Stores/Pkg-1		✓
110	Packaging	1 pcs		11/17/17	0.00	0.00	Packaging1		✓
120	CNC Bend Crosstubes	1 pcs		11/18/17	0.00	4.32	CNC Bend Crosstube		✓
130	QC	1 pcs		11/18/17	0.00	0.00	QC15		✓
140	Crosstubes	1 pcs		11/18/17	0.00	2.87	Crosstube		✓
150	HandFXtube	1 pcs		11/18/17	0.00	0.74	HandFinish5		✓
160	QC	1 pcs		11/18/17	0.00	0.00	QC7		✓ DAS
170	QC	1 pcs		11/18/17	0.00	0.00	QC5		✓ 38
180	Outsource	1 pcs		11/18/17			SKY002-VC		✓ 9-89
190	Packaging	1 pcs		11/18/17	0.00	0.00	Packaging2		✓
200	QC	1 pcs		11/18/17	0.00	0.00	QC5		✓
210	Outsource	1 pcs		11/18/17			ATE003-VC		✓
215	Packaging	1 pcs		11/18/17	0.00	0.00	Packaging2		✓ DAS
220	QC	1 pcs		11/18/17	0.00	0.00	QC14		✓ 38
230	Crosstubes	1 pcs		11/20/17	0.00	2.87	Crosstube		✓ 9-89
240	QC	1 pcs		11/20/17	0.00	0.00	QC5		✓ 38
250	Packaging	1 pcs		11/20/17	0.00	0.00	Packaging1		✓ 9-89
260	QC	1 pcs		11/20/17	0.00	0.00	QC4		✓ 5mB
265	DC	1 pcs		11/20/17	0.00	0.00	DC		
270	Packaging	1 pcs		11/20/17	0.00	0.00	Packaging3		
280	QC21-FG	1 Ea		11/20/17	0.00	0.00	QC21		✓ DAS

Part Op 120 - Bend tube as per Dwg D206-667-147 using CNC bender program

Descriptions: 140 - ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: 9-89 ***** 1- Drill

holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-147. Drill all (3) top holes. Holes facing inboard.

***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: 9-89 ***** 2- Drill Fwd

rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-147. Note: Fwd side has 3x top holes. Facing inboard. 3-

C'sink holes as per Dwg D206-667-147. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch

drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. Drill ONLY 2 top holes ONLY plug

most bottom holes to prevent accidental drilling. Drill holes and ream using drill Jig DT8541 & DT8542 as per Dwg D206-

667-147. Drill only the top (2) holes. ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED

BY: 9-89 ***** 5- Drill Aft rivet holes using drill Jig

150 - *****IMMEDIATELY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID

D206-667-107BL/168325-E/S013149

DART
AEROSPACE
S011818



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Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue

D206-667-107BL

Outsource

PART NO:
Revision:
Operation:
Change No:

Mfg Date: 11/23/17
Job No: 168325-E

ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

210 - ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** ***VERIFY BY _____

BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH

W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per

QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____

PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____

220 - Wrap in plastic bag to protect from scratches ***VERIFY BY _____ BATCH # TO MATCH W/O

***VERIFY BY _____ PART # TO MATCH W/O

230 - 1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe 2-Install supports with Proseal 890 per DSI9565 and QSI 015 A/R Proseal 890 Batch: _____ 3- Torque bolts as per dwg 4-Install nut plates as per Dwg D206-667-147. Touch-up rivet heads with Imron paint.

240 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O

260 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O

265 - Photocopy bluefile and create labels as per PPP D206-667-107 chg 003

270 - Identify and pack for shipping as per D206-667-107 Location: FG035

Proseal 138408 exp 2/18 41 NOV 24 2017 S:Keflex

Job Allocations

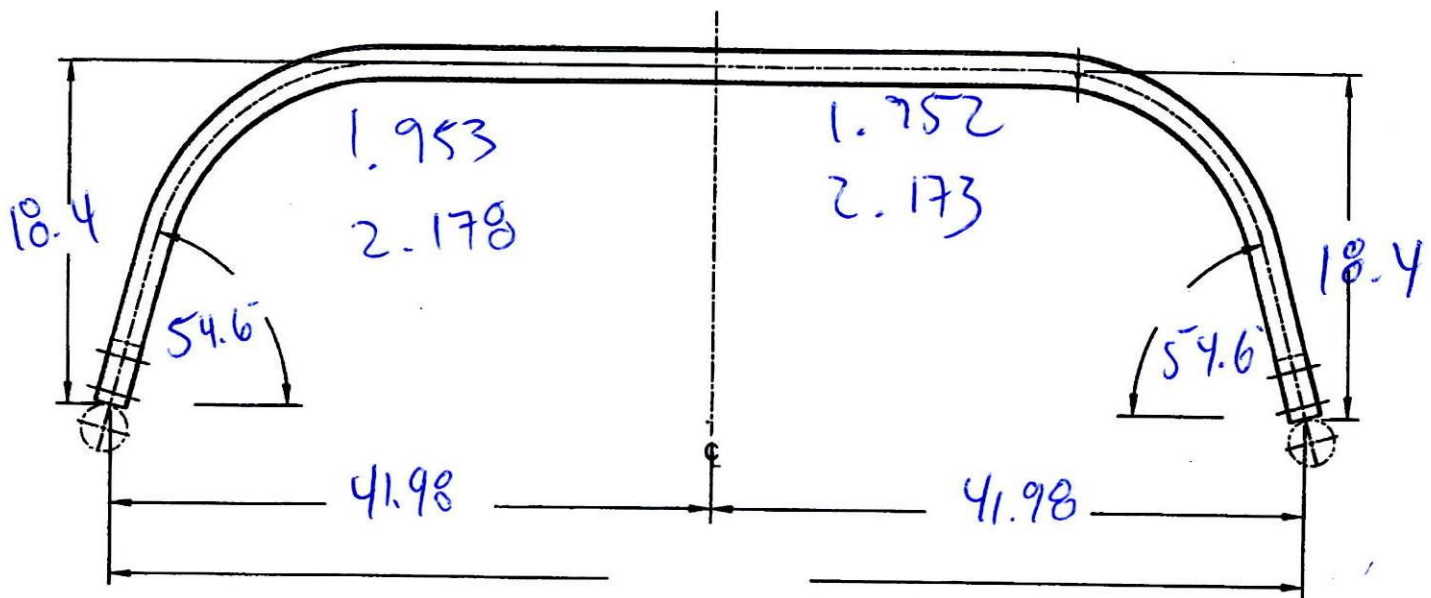
Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D206-667-147TRN	1	6	0	0
230-Crosstubes	D206-667-017 165588	1	13	0	0
	D2873-043 5001319	2	113	0	0
	D2873-045 165660	2	37	0	0
	D2891-1 5000584	2	32	0	0
	D3595-063-395 F164400-0	4	67	0	0
	MS20601-AD4W8 138209	14	387	0	0
	MS21920-20 M137587	4	106	0	0
250-Packaging	AN5-30A 5013940	4	42	0	0
	AN5-32A 5013940	4	141	0	0
	AN5-7A 5013937	10	2,682	0	0
	AN970-4 5013936	12	83	0	0
	MS21042L5 5013935	4	413	0	0
	NAS1149D0563J 5013934	18	1,347	0	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order: 168325-E 162279-A
Description: Crosstube Mid Fwd (206L)		Part Number: D206-667-107
Inspection Dwg: D206-667-147	Rev: A	Page 1 of 1

Required Dimension	Min	Max
Height	18.34	18.60
1/2 Span	41.79	42.05
Angle	54°	56°
Total Span	83.59	84.09
Bending Passes	10	--
Crushing	--	6%



	Side A	Side B
Bending Passes	16	16
Crushing	5.4%	5.4%
Comments		

QC15 Inspection	DAG
Date	38
	9-80

NOV 17 2017

Rev	Date	Change	Revised by	Approved
A	12.02.15	New Issue	KJ	
B	12.04.16	Added bending, crushing dimensions	KJ	

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

PO 038410

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO34098	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO038410
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON 19 CROSSTUBES AS PER PO038410

6 AFT CROSSTUBES , P/N# D119-796-241 , J/S# 164137, 168120, 168119, 165573, 164136, 168330,

5 FWD CROSSTUBES, P/N# D119-796-141 , J/S# 165701, 168121, 165702, 164478 164479

4 FWD CROSSTUBES , P/N# D206-667-107BL , J/S# 168325-C, 168325-D, 168325-E, 168325

4 AFT CROSSTUBES, P/N# D206-667-207BL , J/S# 168327, 168327-A, 168327-B, 168327-G

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417-M13 NO CRACK FOUND PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , EMU. MPO15896, DEV. MPO11715 , UV LIGHT M-20142						NOV 20 2017	
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		NOV 20 2017



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER PO038459

Items												
Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	168325-E	D206-667-107BL		outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Fininsh Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____ Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O ***VERIFY BY _____ PART # TO MATCH W/O ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Fininsh Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____		Firmed	11/23/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
4	168325-C	D206-667-107BL		Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O ***VERIFY BY _____ PART # TO MATCH W/O ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Fininsh Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____		Firmed	11/23/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00